

Date: Wednesday, 25/06/2008 12:00:00 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP LEG
Job Number : 40087A	
Estimate Number : 10353	
P.O. Number :	Part Number : D2278
This Issue : 25/06/2008 S.O. No. :	Drawing Number : D2278 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : F
Previous Run : 37925A	Material :
Written By :	Due Date : 07/07/2008 Qty: 24 Um: Each
Checked & Approved By : <u>JUL 08-06-25</u>	
Comment :	
Est Rev:A New Issue 05-11-07 JLM	
Est Rev:B Now 6061-T6 06-06-23 JLM	
Est Rev C New flat pattern 08.01.11 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 1.0306 sf(s)/Unit Total : 24.7338 sf(s)
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick
 (M6061T62S.080)
 Identify as D2278
 Batch: 108433 HB 8-7-2

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2278
 Dwg Rev: F
 Prog Rev: F

HB 8-7-2

(29)

2-Deburr if necessary

HB 8-7-2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-7-2

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

508107103 counters (29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FR 08/07/04

29

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-07-04

29

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Sylvie

AS 08/07/04

29

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08

Job Completion



U 08.07.07

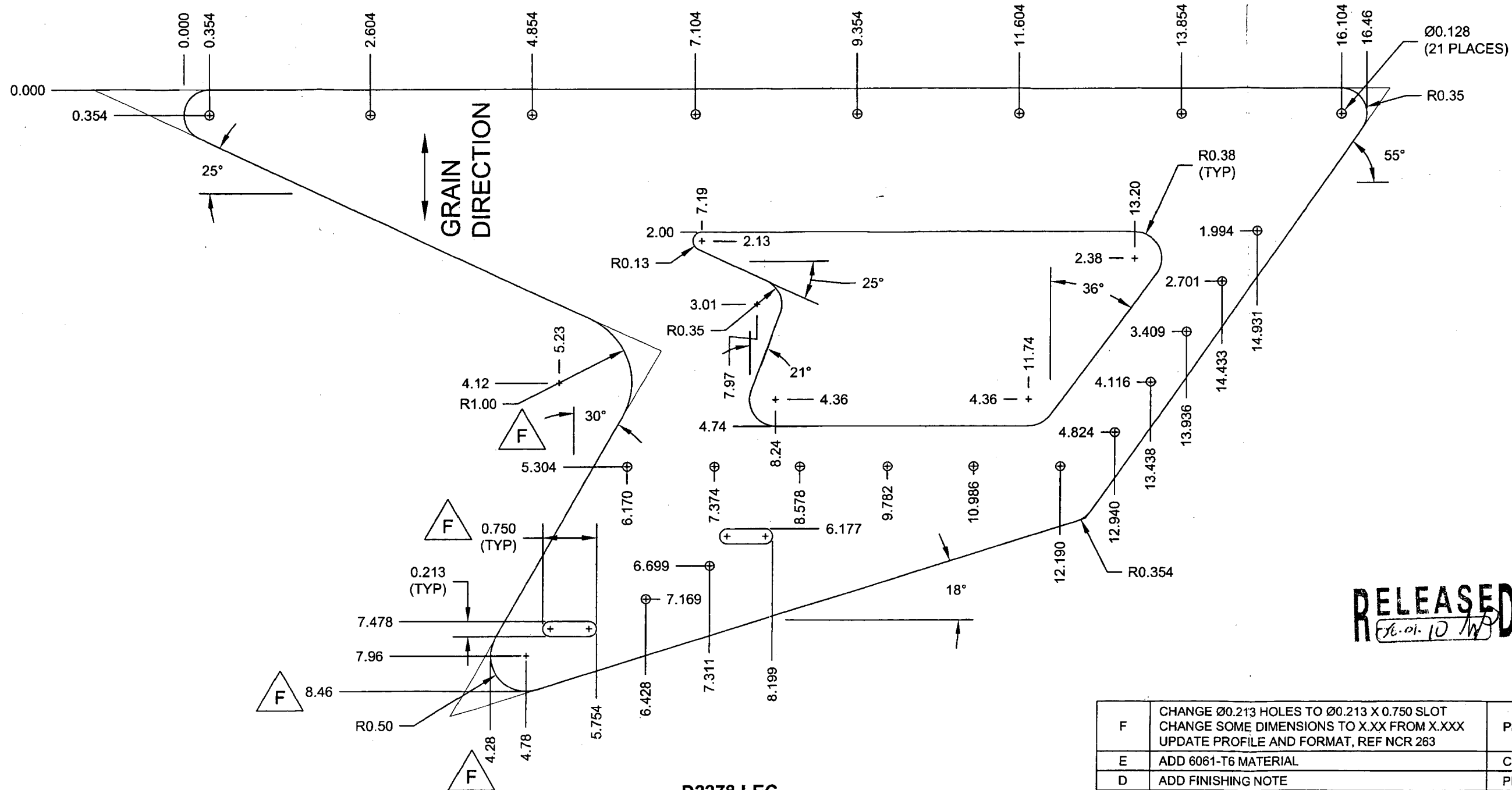
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		180					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.080) OR 5052-H32 ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/8 OR AMS 4016) (REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

D2278 LEG

F	CHANGE Ø0.213 HOLES TO Ø0.213 X 0.750 SLOT CHANGE SOME DIMENSIONS TO X.XX FROM X.XXX UPDATE PROFILE AND FORMAT, REF NCR 263	PH	07.12.27
E	ADD 6061-T6 MATERIAL	CB	06.05.29
D	ADD FINISHING NOTE	PH	05.11.14
C	CHANGED RADIUS TO 0.354	BW	95.02.16
B	CHANGED TO MATCH SPACERS	BW	94.11.08
A	NEW ISSUE	BW	94.10.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RA		
DRAWN	RA		
CHECKED	KE		
MFG. APPR.	KE		
APPROVED	KE		
DE APPR.	KE		
DATE	07.12.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. F
D2278 SHEET 1 OF 1

TITLE SCALE
LEG 3:2

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